

Work Order ID 153169

Tuesday, November 08, 2016 2:15:36 PM

153169

Page 1

Item ID: DSI 9631-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Vibration Isolation Installation

Start Date: 11/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/8/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: 

Date: 16-11-08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9631

A

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI9631-011 CHG001

DAS
21
9-89

NOV 08 2016

DAS
27
9-89

NOV 08 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS DAS
6 28
9-89 9-89

NOV 08 2016

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

NOV 08 2016

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____			DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :		Step #:			QTY Effective :				MRB (QSI042) Approval		
Description Work Order Deviation					Disposition					Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ <u>Offset/Setup</u> ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐					FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						
OTHER :											

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Tuesday, November 08, 2016 2:15:36 PM

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Page 2

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Accept

N900040100

Setup Start

NS1

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Stop

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Item Name: Vibration Isolation Installation

Start Date: 11/8/2016 Start Qty: 1.00

1

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1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9631-011 Location: <u>sold</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89DAS
28
9-89

NOV 08 2016

DAS
21
9-89

NOV 08 2016

11-11-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					

Picklist Print

Tuesday, November 08, 2016 2:15:43 PM

Page 1
4

Work Order ID: 153169

153169

Parent Item: DSI 9631-011

DSI 9631-011

Parent Item Name: Vibration Isolation Installation

Start Date: 11/8/2016

Required Date: 11/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.24 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4713-1 Spacer		Manufactured	No			110	Each	44.0000	1	1			DAS 28 9-89
D4713-1									**	16-11-08			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST121			44		①			
					146084			44					
MS3367-5-0 Tie Wrap		Purchased	No			110	Each	88.0000	1	1			DAS 28 9-89
MS3367-5-0									**	16-11-08			
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST272			88		①			
					123164			88					

NOV 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-797-2 Rev. B,
IIN-D407-797-1 Rev. B AND INSTRUCTIONS FOR
CONTINUED AIRWORTHINESS ICA-D407-797 REV. 1

REF CANADIAN STC: SH11-1

REF FAA STC: SR02996NY

REF EASA STC: 10035429

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to reduce potential vibration on the D3912-041 Eyebolt Receiver Assy. This DSI is applicable to D206-797-021/-022/-023/-024 Quick Release Heli-Utility-Baskets as well as D407-797-011/-012/-013/-014 Quick Release Heli-Utility-Baskets.

2.0 INSTALLATION

- 2.1 Remove the D4272-011/-012/-013/-014 Basket Assy from the aircraft in accordance with Section 25.1 of ICA-D407-797.
- 2.2 Install D4713-1 Spacer with the chamfer side facing inboard by forcing it over the D3912-1 Eyebolt (see Figures 1 & 2). Install MS3367-5-0 Tie Wrap over the D4713-1 Spacer (see Figure 2).
- 2.3 Re-install D4272-011/-012/-013/-014 Basket Assy per Section 25.2 of ICA-D407-797

3.0 MAINTENANCE

- 3.1 During the 300 Hour Inspection of the basket installation, check the physical integrity and security of the D4713-1 Spacer and MS3367-5-0 Tie Wrap. Replace damaged or worn parts as required.

4.0 PARTS LIST

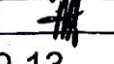
QTY -011	PART NUMBER	DESCRIPTION
	DSI 9631-011	VIBRATION ISOLATION INSTL
1	D4713-1	SPACER
1	MS3367-5-0	TIE WRAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153169
MP 12-11-8

5.0 WEIGHT AND BALANCE

Installation of the DSI 9631-011 Vibration Isolation Kit has negligible effect on Weight and Balance.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	12.09.13
CERT. NO.:	SH11-1
ISSUE NO.:	2

A	NEW ISSUE	AP	12.09.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	NA	DSI 9631	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		VIBRATION ISOLATION INSTL	NTS
DATE	12.09.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DQA: _____ Date: _____



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☐ OTHER : _____					

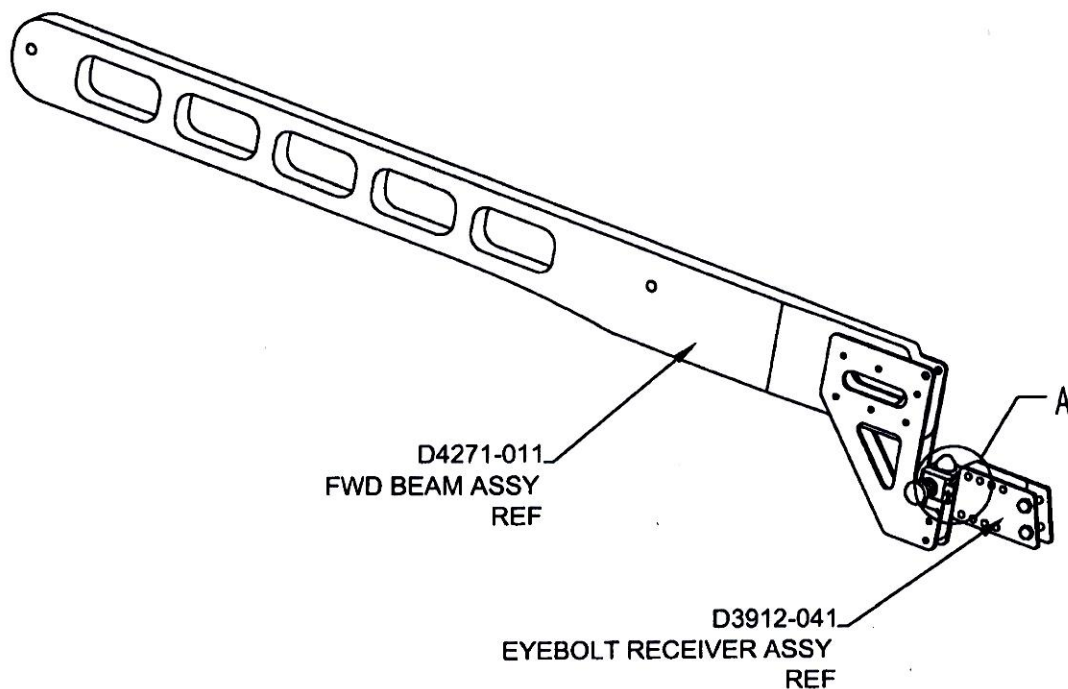
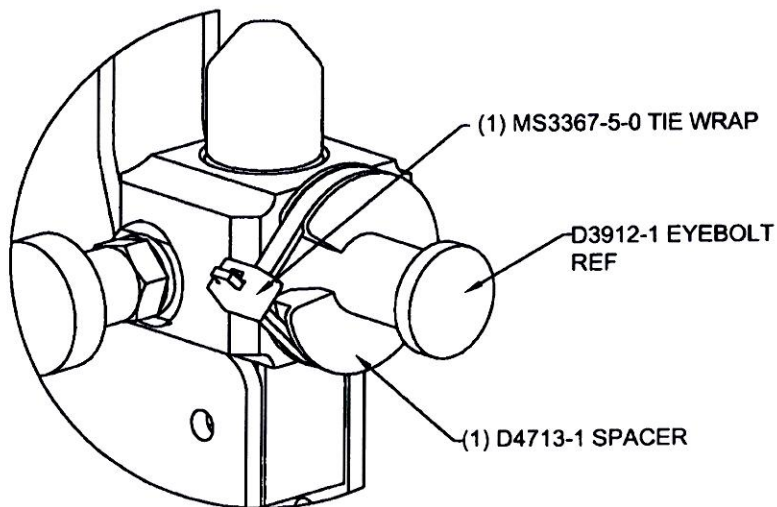


Figure 1 - General Location of Installation
(Basket not shown for clarity)



DETAIL A

Figure 2 - DSI 9631-011 Installation
(D3912-041 Eyebolt Receiver Assy not shown for clarity)

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	NA	DSI 9631	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VIBRATION ISOLATION INSTL	NTS
DATE	12.09.13	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-797-2 Rev. B,
IIN-D407-797-1 Rev. B AND INSTRUCTIONS FOR
CONTINUED AIRWORTHINESS ICA-D407-797 REV. 1

REF CANADIAN STC: SH11-1

REF FAA STC: SR02996NY

REF EASA STC: 10035429

REFERENCE ONLY

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to reduce potential vibration on the D3912-041 Eyebolt Receiver Assy. This DSI is applicable to D206-797-021/-022/-023/-024 Quick Release Heli-Utility-Baskets as well as D407-797-011/-012/-013/-014 Quick Release Heli-Utility-Baskets.

2.0 INSTALLATION

- 2.1 Remove the D4272-011/-012/-013/-014 Basket Assy from the aircraft in accordance with Section 25.1 of ICA-D407-797.
- 2.2 Install D4713-1 Spacer with the chamfer side facing inboard by forcing it over the D3912-1 Eyebolt (see Figures 1 & 2). Install MS3367-5-0 Tie Wrap over the D4713-1 Spacer (see Figure 2).
- 2.3 Re-install D4272-011/-012/-013/-014 Basket Assy per Section 25.2 of ICA-D407-797

3.0 MAINTENANCE

- 3.1 During the 300 Hour Inspection of the basket installation, check the physical integrity and security of the D4713-1 Spacer and MS3367-5-0 Tie Wrap. Replace damaged or worn parts as required.

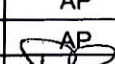
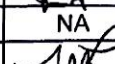
4.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
	DSI 9631-011	VIBRATION ISOLATION INSTL
1	D4713-1	SPACER
1	MS3367-5-0	TIE WRAP

5.0 WEIGHT AND BALANCE

Installation of the DSI 9631-011 Vibration Isolation Kit has negligible effect on Weight and Balance.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	12.09.13
CERT. NO.:	SH11-1
ISSUE NO.:	2

A	NEW ISSUE	AP	12.09.13
REV.	DESCRIPTION	BY	DATE
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DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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